

Work Order ID 110564

December-31-13 7:05:41 AM

110564

Page 1

Item ID: D2370-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Litter Frame Assembly
 Start Date: 12/31/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/10/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: CZ Date: 14/01/07 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2370	REV D								

100 PURCHASING 0.00
100
 Purchasing CZ 14/01/08 ①

Purchasing Memo 0.00
 Issue p/o: 22542
 Order: Model 12-2A undrilled with grey pad & black belts
 Supplier: Ferno Aviation
 Letter of compliance required

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Insure that letter of compliance is attached to w/o 14/01/22 ①

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00 14/1/22
 Quality Control

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Item Name: Litter Frame Assembly
Start Date: 12/31/13 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/10/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					1			FF
Small Fab	Memo	0.00							23-01-14
Small Fab	1- Assemble D2374 STUDS WITH HARDWARE as per Dwg D2370 2-Assemble d2379 belt as per dwg								
140	QC5- Inspect part completeness to step on W/O	0.00				1			
140									
QC	Memo	0.00							
Quality Control	Check for loose rivet and ensure fit of D4812-041								
150	Identify as per dwg & Stock Location: <u>57/96A</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

DAS 27 9-89 14/1/24

14/01/24 (1) DAS 32 9-89

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Item ID: D2370-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Litter Frame Assembly

Stop

NS2

Start Date: 12/31/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/10/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 14-01-27

14-01-24

Picklist Print


December-31-13 7:05:40 AM

Page 1

Work Order ID: 110564
 Parent Item: D2370-1
 Parent Item Name: Litter Frame Assembly

Start Date: 12/31/13
 Start Qty: 1.00
 Required Date: 1/10/14
 Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D2370-1P Litter Frame Assembly		Purchased	No				Each	0.0000		110564			
D2374 Stud		Manufactured	No				Each	39.0000		4	FF	23-01-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		39							
				103860		13							
				98114		26				4			
D2378 Bolt		Manufactured	No				Each	20.0000		4	FF	23-01-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009	110798	20				4			
				97240		20							
D2484 Locknut		Manufactured	No				Each	36.0000		4	FF	23-01-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		36							
				22016		36				4			
NAS1149D0416J WASHER		Purchased	No				Each	420.0000		4	FF	23-01-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		215							
				m126254		215							
				ST294		205							
				m125773		11							
				m127832		194				4			

D2370-1 LITTER FRAME ASSEMBLY

D4812-041 PATIENT STOP ASSY

POSITION PATIENT STOP OVER
FWD STUDS AND SECURE
WITH PIP PINS

D2370-041 LITTER ASSEMBLY

NOTES:

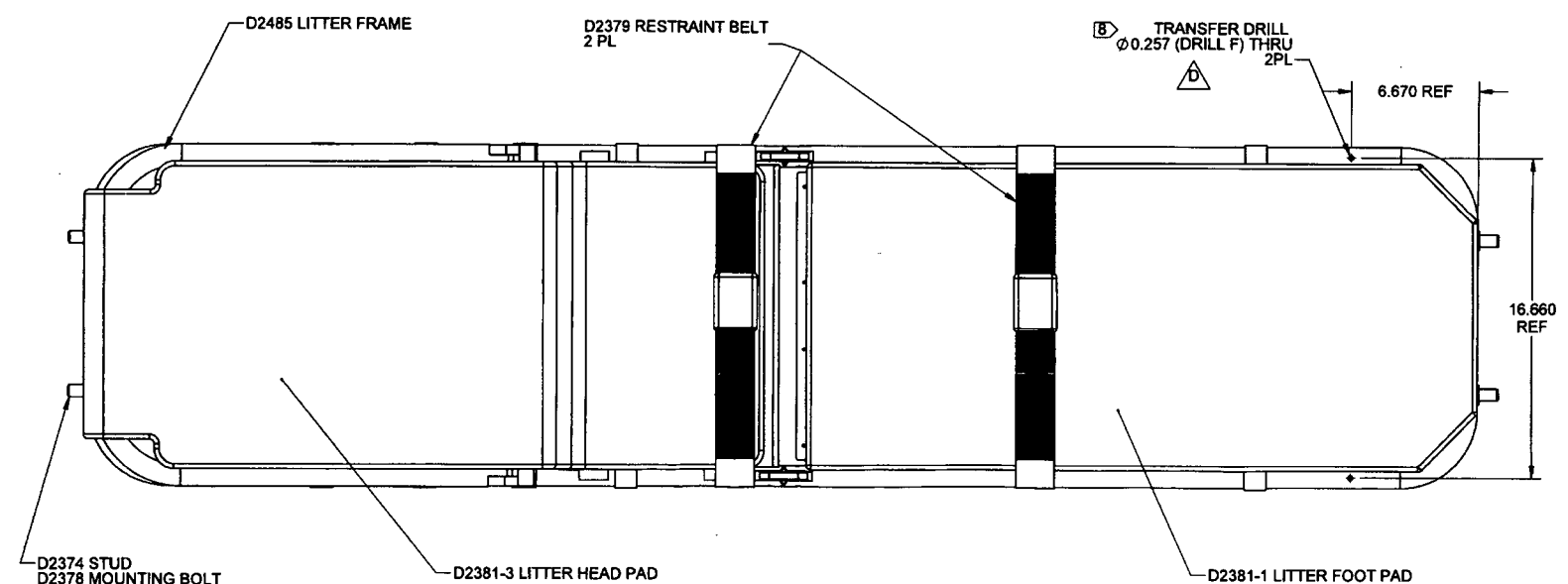
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 25.73 Lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D2370-041	LITTER ASSEMBLY
1	1	D2370-1	LITTER FRAME ASSY
2	1	D4812-041	PATIENT STOP ASSY

RELEASED
2013-05-16

D	Ø0.257 HOLES WERE Ø0.191 HOLES, 2PL (ZN C3-2), CREATED -1 AND -041 ASSEMBLIES, NEW DWG FORMAT	DB	13.03.27
C	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES AND 5.00 WAS 5.34	KE	06.11.21
B	ADDED Ø0.181 HOLES	KE	98.06.09
A	NEW ISSUE	NA	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	AP	D2370	SHEET 1 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	LITTER ASSEMBLY	NTS
DATE	13.03.27	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -1	P/N	DESCRIPTION
	X	D2370-1	LITTER ASSEMBLY
1	4	D2374	STUD
2	4	D2378	MOUNTING BOLT
3	2	D2379	RESTRAINT BELT
4	1	D2381-1	LITTER FOOT PAD
5	1	D2381-3	LITTER HEAD PAD
6	4	D2484	LOCK NUT
7	1	D2485	LITTER FRAME
8	4	AN960JD416L	WASHER



D2370-1 LITTER ASSEMBLY

RELEASED
2013-05-16

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2370-1" USING A REMOVABLE TAG AS PER QS1 044 METHOD 6.6
 - 7) WEIGHT: 24.69 Lbs
 - 8) TRANSFER DRILL USING D4812-041 AS TEMPLATE. ENSURE FIT AND REMOVE FOR SHIPPING

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	AP	D2370	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	LITTER ASSEMBLY	NTS
DATE	13.03.27	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO22542**

Purchase Order Date 1/8/2014

PO Print Date 1/8/2014

Page Number 1 of 2

Order From :

VU-FER001

Ship To : DART AEROSPACE LTD

FERNO AVIATION INC.
735-B BRANCH DR.
ALPHARETTA, GA 30004
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
1/10/14

Contact Name

Vendor Phone 770 521 1005

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2370-1P	Litter Frame Assembly	1/22/2014 Yes 1/22/2014		1.00 Each	\$1,706.00	\$1,706.00
AS PER DWG D2370 REV. D B110564 MODEL 12-2A UNDRILLED WITH GREY PAD & BLACK BELTS							
Line Total:							\$1,706.00
2	D2370-1P	Litter Frame Assembly	1/22/2014 Yes 1/22/2014		1.00 Each	\$1,706.00	\$1,706.00
AS PER DWG D2370 REV. D B110565 MODEL 12-2A UNDRILLED WITH GREY PAD & BLACK BELTS							
Line Total:							\$1,706.00

Note:

1/8/2014

FERNO Aviation, INC.

735-B Branch Drive
Alpharetta, GA 30004
Office 770.521.1005 Fax 770.521.0910
<http://aviation.ferno.com>

Commercial Invoice

DATE	INVOICE NO.
1/17/2014	13875

BILL TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Attn: Accounts Payable

SHIP TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Ref: PO# 22542

PO NO.	TERMS	REP	SHIP DATE	SHIP VIA	FOB
22542	Net 30	CW	1/17/2014	fedEx Int'l Pri	Alpharetta, GA
ITEM	DESCRIPTION	QTY	UNIT PRICE	AMOUNT	
12-2A (DART)	12-2A Litter Assembly W/Gray FAA Approved cover/pad assy. and Black FAA approved patient restraints S/N: 13N261667, 13N272654, 13N272655, 13N27265 (HS Code 8803.30.00.00) Notes: 1. Ship Collect via FedEx P1 2. Tracking # 7976 6066 0830 7976 6066 0554 7976 6066 0841 7976 6066 0863	4	1,706.00	6,824.00	
				Total	\$6,824.00